



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2842-042
Job Sheet 210887



Part No: D2842-042

Job Qty: 2 pcs

Part Name: Step Assembly RH, 206 Float



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/25/20

Job Tracking No:

Due Date: 7/13/20

Created By: Linda Lacelle

Type: Stock

Description: *Step*

Note: DWG REV C IPP Rev:D As Per Ecn 766 06-01-06 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Steps - 1	2 pcs			0.00	2.88	Large Fab - 1		<i>2007-11</i>
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4	DAS 24	
							Large Fab - 5	9-89	
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
105	QC 5	2 pcs			0.00	0.00	QC 5 - 10		<i>2007-13</i>
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24	DAS 43	
							QC 5 - 3	9-89	
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		



Container No: S288356



Part: D2842-042

Job No: 210887

Serial No/Batch: S288356

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/16/20

FG039

110 Large Fab - Steps - 2 - B4B	2 pcs	0.00 2.88 7h	QC 5 - 82	
			Large Fab - 1 - B4B	
			Large Fab - 10 - B4B	
			Large Fab - 2 - B4B	
			Large Fab - 3 - B4B	
			Large Fab - 4 - B4B	
			Large Fab - 5 - B4B	DAS
			Large Fab - 6 - B4B	43
			Large Fab - 7 - B4B	9-89
			Large Fab - 8 - B4B	
			Large Fab - 9 - B4B	200720
			Large Fab - 11 - B4B (Various)	
			Large Fab - 12 - B4B	
120 QC 9	2 pcs	0.00 0.00	QC 9 - 10	
			QC 9 - 18	DAS
			QC 9 - 24	24
			QC 9 - 43	9-89
			QC 9 - 50	
			QC 9 - 9	
130 QC 5	2 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	DAS
			QC 5 - 51	24
			QC 5 - 58	9-89
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
			QC 5 - 82	
140 Handfinish - 1-1 Chemical-B4B	2 pcs	0.00 0.82	Handfinish - 1 - 1 - B4B	
			Handfinish - 1 - 2 - B4B	
			Handfinish - 1 - 3 - B4B	
			Handfinish - 1 - 4 - B4B	
			Handfinish - 1 - 5 - B4B	
			Handfinish - 1 - 6 - B4B	
			Handfinish - 1 - 7 - B4B	
			Handfinish - 1 - 8 - B4B	
			Handfinish - 1 - 9 - B4B	
			Handfinish - 1 - 10 - B4B	
			Handfinish - 1 - 11 - B4B	
			Handfinish - 1 - 12 - B4B	
			Handfinish - 1 - 13 - B4B	
			Handfinish - 1 - 14 - B4B	
			Handfinish - 1 - 15 - B4B	
			Handfinish - 1 - 16 - B4B	
			Handfinish - 1 - 17 - B4B	
			Handfinish - 1 - 18 - B4B	
			Handfinish - 1 - 19 - B4B	

			Handfinish - 1 - 20 - B4B	
			Handfinish - 1 - 21 - B4B	
			Handfinish - 1 - 22 - B4B	NO 200/04/21
150 QC 7	2 pcs	0.00 0.00	QC 7 - 10	
			QC 7 - 13	
			QC 7 - 14	
			QC 7 - 15	
			QC 7 - 17	
			QC 7 - 18	
			QC 7 - 19	
			QC 7 - 2	
			QC 7 - 28	
			QC 7 - 3	
			QC 7 - 30	
			QC 7 - 34	
			QC 7 - 36	
			QC 7 - 37	
			QC 7 - 41	
			QC 7 - 47	
			QC 7 - 48	
			QC 7 - 51	
			QC 7 - 58	
			QC 7 - 59	
			QC 7 - 60	
			QC 7 - 9	
			QC 7 - 68	
			QC 7 - 50	
			QC 7 - 67	
			QC 7 - 40	
			QC 7 - 24	
			QC 7 - 43	DAS
			QC 7 - 61	43
			QC 7 - 81	9-89
			QC 7 - 76	
			QC 7 - 79	work
			QC 7 - 83	
			QC 7 - 82	
			QC 7 - 87	
160 Large Fab - Steps - 3 - B4B	2 pcs	0.00 2.88	Large Fab - 1 - B4B	
			Large Fab - 10 - B4B	
			Large Fab - 2 - B4B	
			Large Fab - 3 - B4B	
			Large Fab - 4 - B4B	
			Large Fab - 5 - B4B	
			Large Fab - 6 - B4B	
			Large Fab - 7 - B4B	
			Large Fab - 8 - B4B	
			Large Fab - 9 - B4B	
			Large Fab - 11 - B4B (Various)	
			Large Fab - 12 - B4B	
170 QC 10	2 pcs	0.00 0.00	QC 10 - 10	
			QC 10 - 18	
			QC 10 - 24	
			QC 10 - 43	DAS
			QC 10 - 50	24
			QC 10 - 58	9-89
			QC 10 - 9	
			QC 10 - 68	

180 QC 5	2 pcs	0.00 0.00	QC 10 - 81	
			QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
			QC 5 - 82	
185 Handfinish - 2-1 Pressure-B4B	2 pcs	0.00 0.82	Handfinish - 2 - 1 - B4B	
			Handfinish - 2 - 2 - B4B	
			Handfinish - 2 - 3 - B4B	
			Handfinish - 2 - 4 - B4B	
190 Powdercoat - 1 White GI(A)-B4B <i>M 254469.</i>	2 pcs	0.00 0.35	Powdercoat - 1 - B4B	
			Powdercoat - 2 - B4B	
			Powdercoat - 3 - B4B	
			Powdercoat - 4 - B4B	
			Powdercoat - 5 - B4B	
			Powdercoat - 6 - B4B	
			Powdercoat - 7 - B4B	
			Powdercoat - 8 - B4B	
			Powdercoat - 9 - B4B	
			Powdercoat - 10 - B4B	
200 QC 3	2 pcs	0.00 0.00	QC 3 - 10	
			QC 3 - 13	
			QC 3 - 15	
			QC 3 - 17	
			QC 3 - 18	
			QC 3 - 2	
			QC 3 - 28	
			QC 3 - 3	
			QC 3 - 30	
			QC 3 - 34	
			QC 3 - 36	
			QC 3 - 41	
			QC 3 - 51	
			QC 3 - 58	
			QC 3 - 59	
			QC 3 - 68	
			QC 3 - 9	
			QC 3 - 40	
			QC 3 - 19	
			QC 3 - 43	
			QC 3 - 24	
			QC 3 - 61	
			QC 3 - 81	
			QC 3 - 82	

DAS
24
9-89

7/29/20

838

20-07-29

START: 2:35
CUT: 3:00
FINISH: 3:05

20 07-29

DAS
15
9-89

M 20-7-30

210 Handfinish - 3-1- WingWalk-B4B	2 pcs	0.00 0.82	QC 3 - 87				
			Handfinish - 3 - 1 - B4B	M 20.7 30			
			Handfinish - 3 - 2 - B4B				
			Handfinish - 3 - 3 - B4B				
			Handfinish - 3 - 4 - B4B				
220 QC 5	2 pcs	0.00 0.00	Handfinish - 3 - 5 - B4B				
			QC 5 - 10				
			QC 5 - 12				
			QC 5 - 17				
			QC 5 - 18				
			QC 5 - 19				
			QC 5 - 22				
			QC 5 - 24				
			QC 5 - 3				
			QC 5 - 43				
			QC 5 - 49				
			QC 5 - 51				
			QC 5 - 58				
			QC 5 - 68				
			QC 5 - 9				
			QC 5 - 50	DAS			
			QC 5 - 30	81			
			QC 5 - 40	9-89			
			230 Packaging 3-1 - Stock - B4B	2 pcs	0.00 0.00	QC 5 - 61	
						QC 5 - 81	
QC 5 - 82							
Packaging 3 - 1 - B4B							
Packaging 3 - 2 - B4B							
Packaging 3 - 3 - B4B							
Packaging 3 - 4 - B4B							
Packaging 3 - 5 - B4B							
Packaging 3 - 6 - B4B							
Packaging 3 - 7 - B4B							
Packaging 3 - 8 - B4B							
Packaging 3 - 9 - B4B							
Packaging 3 - 10 - B4B							
Packaging 3 - 11 - B4B							
Packaging 3 - 12 - B4B							
Packaging 3 - 13 - B4B							
Packaging 3 - 14 - B4B							
Packaging 3 - 15 - B4B							
Packaging 3 - 16 - B4B							
Packaging 3 - 17 - B4B							
Packaging 3 - 18 - B4B							
Packaging 3 - 19 - B4B							
Packaging 3 - 20 - B4B							
Packaging 3 - 21 - B4B							
Packaging 3 - 22 - B4B							
Packaging 3 - 23 - B4B							
Packaging 3 - 24 - B4B	DAS						
Packaging 3 - 25 - B4B	72						
Packaging 3 - 26 - B4B	9-89						
Packaging 3 - 27 - B4B							
Packaging 3 - 28 - B4B							
Packaging 3 - 29 - B4B							
Packaging 3 - 30 - B4B							
Packaging 3 - 31 - B4B							
Packaging 3 - 32 - B4B							
Packaging 3 - 33 - B4B							
			Plex 6/25/20 10:04 AM dart.lacelle.linda				

240 QC 21 - SA	2 pcs	0.00 0.00	Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	
			QC 21 - SA - 21	DAS
			QC 21 - SA - 70	21
			QC 21 - SA - 9	9-89
			QC 21 - SA - 77	

AUG 04 2020

Part Op 100 - (Fabricate per Drwg) 1-Cut D2842-1 using D2622 extrusion as per Dwg D2842 2-Drill D2842-1 using Jig DT8272 as Descriptions: per Dwg D2842 ***DO NOT OPEN HOLES*** 3-Deburr and bevel ends for welding

105 - QC5- Inspect part completeness to step on W/O

110 - (Weld per dwg A/R Aluminum rod Batch: 139019) -Weld one end cap and (2) lugs using DT10058 as per Dwg D2842 2- OPEN HOLES TO SIZE AS PER DWG (0.250") 3-Grind end cap weld flush

120 - (QC9- Inspect visual per QSI004- Fusion Welds)

130 - (QC5- Inspect part completeness to step on W/O)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (QC7-Inspect Chemical Conversion Coat)

160 - (Weld per dwg A/R Aluminum rod Batch: 139019) 1-Remove alodine prior to welding. Weld end cap as per Dwg D2842. 2-Grind end cap weld flush.

170 - (QC10- Inspect visual per QSI004- ground welds)

180 - (QC5- Inspect part completeness to step on W/O)

185 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) ***Touch up step with alodine per qsi 005 prior to powder coat***

190 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____

200 - (QC3- Inspect Part Finish)

210 - (Wing Walk as per dwg QSI005 4.4 Batch _____) 1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI 005 4.1 Batch: _____

220 - (QC5- Inspect part completeness to step on W/O)

230 - (Identify as per dwg & Stock Location: _____)

240 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	2 pcs (1 ea)	100-Large Fab - Steps - 1	5243427
D2734	Step End Plate	4 pcs (2 ea)	100-Large Fab - Steps - 1	5259367
D3459-1	Float Step Mounting Plate	4 pcs (2 ea)	100-Large Fab - Steps - 1	5241255
D3459-3	Float Step Mounting Plate	4 pcs (2 ea)	100-Large Fab - Steps - 1	5241312
MS27039C1-07	Screw	6 Ea (3 ea)	210-Handfinish - 3-1- WingWalk-B4B	5247846
NAS1149C0332R	Washer (AN960C10L)	6 Ea (3 ea)	210-Handfinish - 3-1- WingWalk-B4B	5285409
NAS1329C3KB130	Insert	6 Ea (3 ea)	210-Handfinish - 3-1- WingWalk-B4B	5023251
NAS1515H3L	Washer	6 Ea (3 ea)	210-Handfinish - 3-1- WingWalk-B4B	52686651

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Steps - 1	D2622-120C	2	257	0
	D2734	4	52	0
	D3459-1	4	18	0
	D3459-3	4	23	0
	MS27039C1-07	6	41	0
210-Handfinish - 3-1- WingWalk-B4B	NAS1149C0332R	6	1,935	0
	NAS1329C3KB130	6	42	0
	NAS1515H3L	6	182	0

Part Specifications

Specifications could not be found.